

Date: Friday, 22/08/2008 10:03:50 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 41588		Part Number	: D2572		
Estimate Number	: 10531		Drawing Number	: D2572 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	: 22/08/2008		Drawing Revision	: E		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 12/09/2008		
Previous Run	: 40515		Qty:	8 Um: Each		
Written By	:					
Checked & Approved By	: <u>JLD 08.8.20</u>					
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>B34874</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>8F</u> Double check by: <u>JL</u>	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/08/2008 10:03:50 AM
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Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MK 08/09/23 8

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/09/26

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8x

7.0 POWDER COATING

POWDER COATING



M 108523



8x

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: *1:15*

1:15

OVEN TEMPERATURE: *320°F*

320°F

FINISH TIME: *1:45*

1:45

MK 08/09/26

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

gladys SP



8x

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *432*

8/9/08



8x

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



08/09/30 ff

Job Completion



08/09/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	41588
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.000	8.002		
F	0.490	0.510		.505	.500	.508	.501		
G	0.257	0.262		.258	.258	.259	.259		
H	0.375	0.380		.376	.376	.377	.377		
I	0.490	0.510		.500	.500	.504	.503		
J	1.174	1.184		1.178	1.178	1.178	1.177		
K	0.558	0.578		.569	.568	.570	.570		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.495	1.495	1.495	1.494		
N	2.495	2.505		2.500	2.500	2.499	2.499		
O	3.869	3.879		3.874	3.874	3.872	3.873		
P	0.115	0.135		.125	.125	.126	.127		
Q	0.115	0.135		.135	.131	.135	.135		
R	0.240	0.260		.254	.254	.257	.250		
S	0.115	0.135		.130	.130	.131	.133		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.966		
V	0.230	0.250		.242	.242	.240	.241		
W	0.115	0.135		.131	.131	.129	.130		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.360	.357	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.627	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.252	.252		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.125	.125	.135	.135		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.257	.257		
AI	2.000	2.020		2.000	2.000	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	<i>SM</i>	Audited by:	<i>J.L</i>
Date:	<i>08/09/22 / 08/09/23</i>	Date:	<i>08/09/26</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JL</i> <i>JL</i>	

DART AEROSPACE LTD				Work Order:	41588
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D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.000	8.000		
F	0.490	0.510		.501	.502	.501	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.502	.503	.501	.503		
J	1.174	1.184		1.179	1.178	1.178	1.178		
K	0.558	0.578		.570	.561	.570	.571		
L	1.174	1.184		1.179	1.177	1.178	1.178		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.499	2.498	2.498		
O	3.869	3.879		3.874	3.873	3.873	3.872		
P	0.115	0.135		.127	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.250	.251	.250		
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Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.366	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.627	.627	.628		
AC	0.053	0.073		.063	.063	.063	.063		
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AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.258	.256		
AH	0.240	0.260		.251	.251	.250	.250		
AI	2.000	2.020		2.003	2.001	2.003	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		

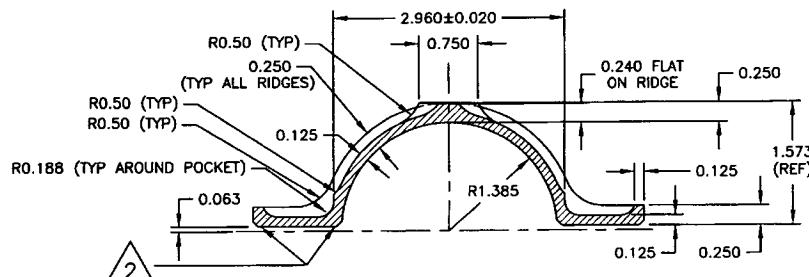
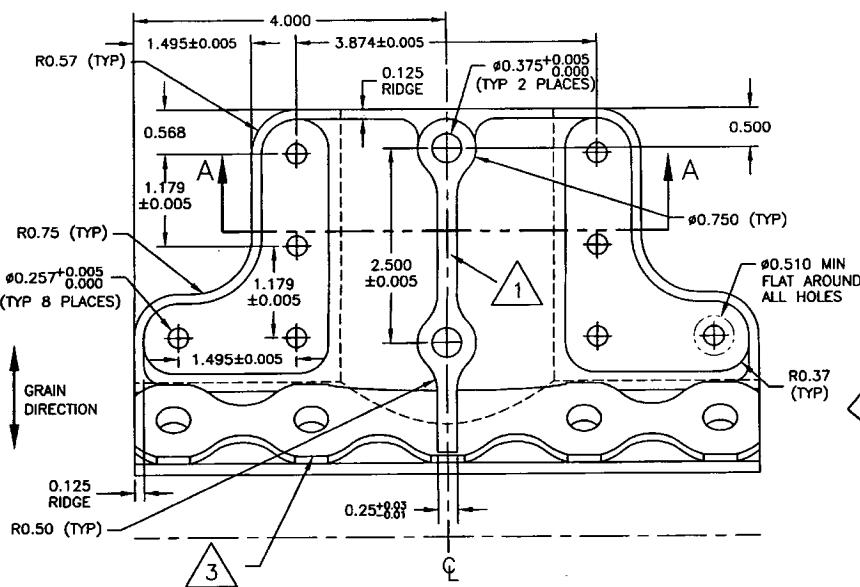
Accept/Reject

Measured by:	<i>cmf</i>	Audited by:	<i>JL</i>
Date:	08/09/23	Date:	08/09/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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E	05.12.05	Added dimension AJ	KJ/JLM <i>cmf</i> <i>cmf</i>	

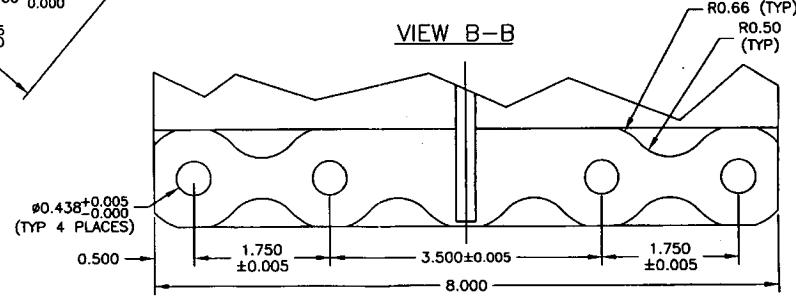
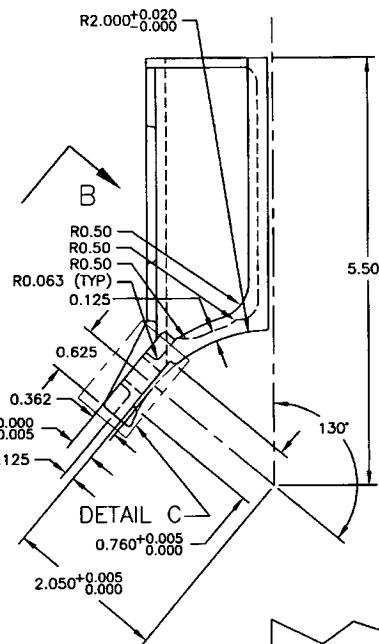
RELEASED

05.12.06



SECTION A-A

DETAIL C
SCALE 2:1



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DS	PH	DART
CHECKED	APPROVED	DRAWING NO. D2572
DATE		REV. E SHEET 1 OF 1 TITLE INNER FWD SADDLE SCALE 2:3
05.07.13		

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